

Work Order ID 145808

Friday, May 06, 2016 10:54:56 AM

145808

Page 1

Item ID: D4271-027 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting Assembly Aft Beam
 Start Date: 5/3/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: MAY 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	D		2		DAS				
100		0.00		6					
100				9-89					
Small Fab	Memo	1.20							
Small Fab	Assemble as per dwg D4271 REAM HOLE AS PER DWG CUT RIVET AT 1.130" C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	Identify as per dwg & Stock Location: <u>51376</u>	0.00							
120									
Packaging	Memo	0.02							
Packaging									

OCT 19 2016

3x

16/10/2036
DAS 9-89

DAS 38 9-89

3

OCT 20 2016

3

OCT 21 2016

68-8
DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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OCT 21 2016

VS 16/10/21
DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER : _____			

Picklist Print

Friday, May 06, 2016 10:54:55 AM

Page 1

Work Order ID: 145808

145808

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3 *D4148-3* Stud Receiver, Lower		Manufactured	No			100	Each	17.0000	1	23 14609/	DAS 6 9-89	OCT 19 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST086				17					
				142482				17					
D4148-5 *D4148-5* Eyebolt Stud		Manufactured	No			100	Each	21.0000	1	23 14692/6	DAS 6 9-89	OCT 19 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST086				21					
				139038				1					
				143355				20					
D4281-3 *D4281-3* Spacer		Manufactured	No			100	Each	4.0000	1	23 14599/6	DAS 6 9-89	OCT 19 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				4					
				123097				4					
D4419-3 *D4419-3* Aft Support Plate		Manufactured	No			100	Each	3.0000	2	46 145710x2	DAS 6 9-89	OCT 19 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST097				3					
				122964				3					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

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Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

AN4C13A Purchased No

100 Each

133.0000

2

46

AN4C13A

BOLT

**

135135

OCT 19 2016

DAS
6
9-69

Location

Loc Qty

Loc Code

OVER002

50

m134508

50

over003

50

m134497

50

ST344

33

m134365

3

m134573

30

MS20427M4-20 Purchased No

100 Each

93.0000

1

23

MS20427M4-20

RIVET

**

OCT 19 2016

DAS
6
9-69

Location

Loc Qty

Loc Code

GA

93

118429

93

MS20615-4M18 Purchased No

100 Each

223.0000

10

2030

MS20615-4M18

Rivet

**

135127x12
135704x

OCT 19 2016

DAS
6
9-69

Location

Loc Qty

Loc Code

OVER007

100

m134502

50

m134606

50

ST306

123

m134134

23

m134370

50

m134676

50

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

889.0000

2

MS21043-4

Nut

**

135407

DAS

6

9-89

OCT 19 2016

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

95

m132803

95

OVER007

300

m134502

300

ST302

454

m133769

12

m134249

142

m134634

300

NAS1149C0432R

Purchased

No

100

Each

1,857.000

4

NAS1149C0432R

WASHER

**

135544

DAS

6

9-89

OCT 19 2016

Location

Loc Qty

Loc Code

GA

428

m125807

428

ST266

1429

m134073

429

m134676

1000

Friday, May 06, 2016 10:54:55 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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